

Work Order ID 153641

Wednesday, November 23, 2016 11:50:16 A

153641

Page 1

Item ID: D3536-25

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Center

Start Date: 11/23/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan: Date: 16-11-23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.21

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary252016/11/29

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control

252016/11/29

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.08

Quality Control

25DAS
38
9-89

NOV 29 2016



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐		
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐		
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐				
Date :		Step #:			QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation					Disposition					Completed By		
										Lead hand / Supervisor Approval Verification		
										QC / QA Coordinator Approval		
Root Cause					FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	
Past Expiry Date ☐	☐	Manufacturing Process										
Misidentified ☐	☐	Past Due	OTHER :									

Work Order ID 153641

Wednesday, November 23, 2016 11:50:16 A

153641

Page 2

Item ID: D3536-25

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Center

Start Date: 11/23/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

LOCATION : FP001

0.04

25

NOV 30 2016

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.42

DAS
21
9-89

NOV 30 2016

DAS
21
9-89

NOV 30 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
CAP 3 3B-4									
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Wednesday, November 23, 2016 11:50:21 AM

Page 1

Work Order ID: 153641

153641

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 11/23/2016

Required Date: 11/24/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	150.2668	0.5956	16.54444			

MNEO60S 063

NEOPRENE SHEET 0.063

see 11/29

Location

Loc Qty

Loc Code

MAT

137.4

M135551

137.4

MAT052

12.866778

M134972

12.866778

17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD		Work Order:	153641
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	1		Visual	
16.35	+/-0.030	16.35	1		Tape	
10.90	+/-0.030	10.90	1			
5.45	+/-0.030	5.45	1			
6.00	+/-0.030	6.00	1			
6.75	+/-0.030	6.75	1			
12.75	+/-0.030	12.75	1			
1.89	+/-0.030	1.89	1			
0.30	+/-0.030	.30	1			
0.30	+/-0.030	.30	1			
Ø0.19	+0.005/-0.001	Ø.19	1			

Measured by:	ac	Audited by:	DAS 38 9-89	Prototype Approval:	N/A
Date:	16/11/29	Date:	NOV 29 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE

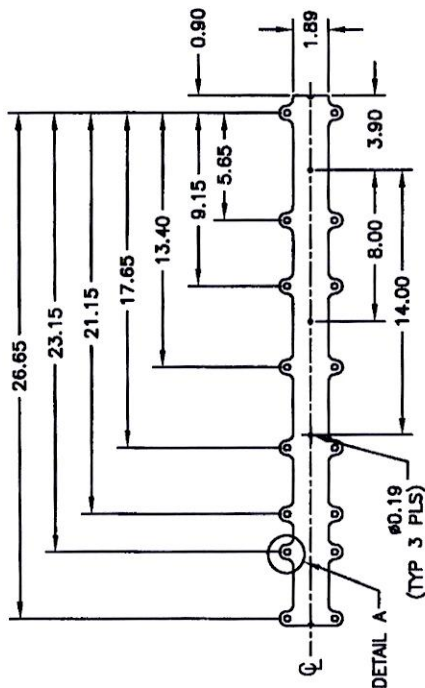
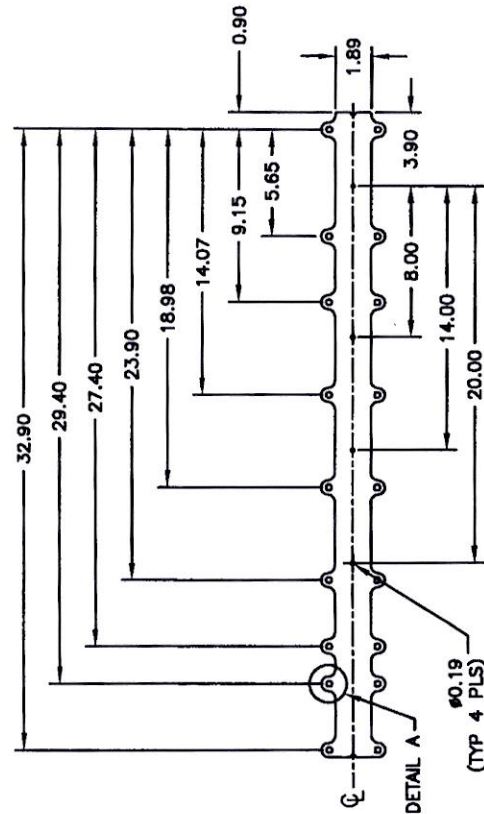
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

09.03.12

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **15364**
16.11.23

**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

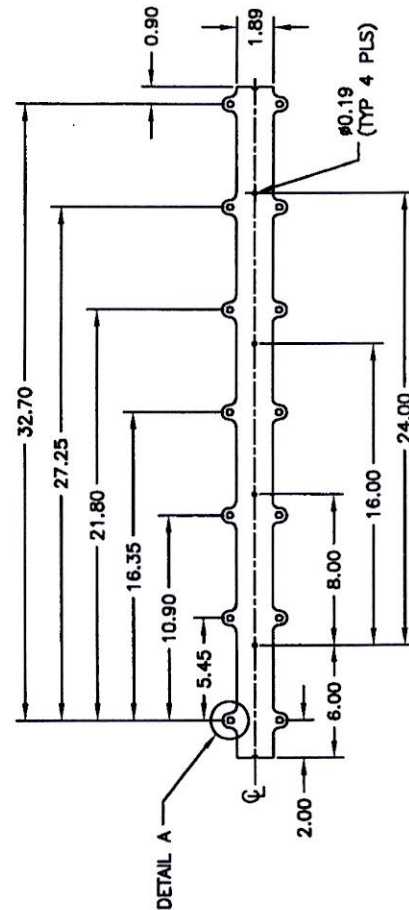
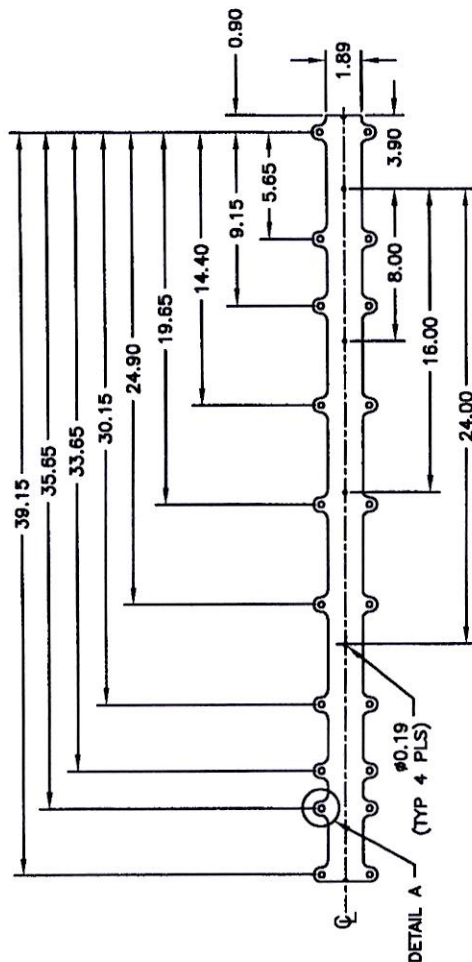
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DATE 06.10.25	TITLE GASKET	SCALE 1:10	

RELEASED
07.02.12 #

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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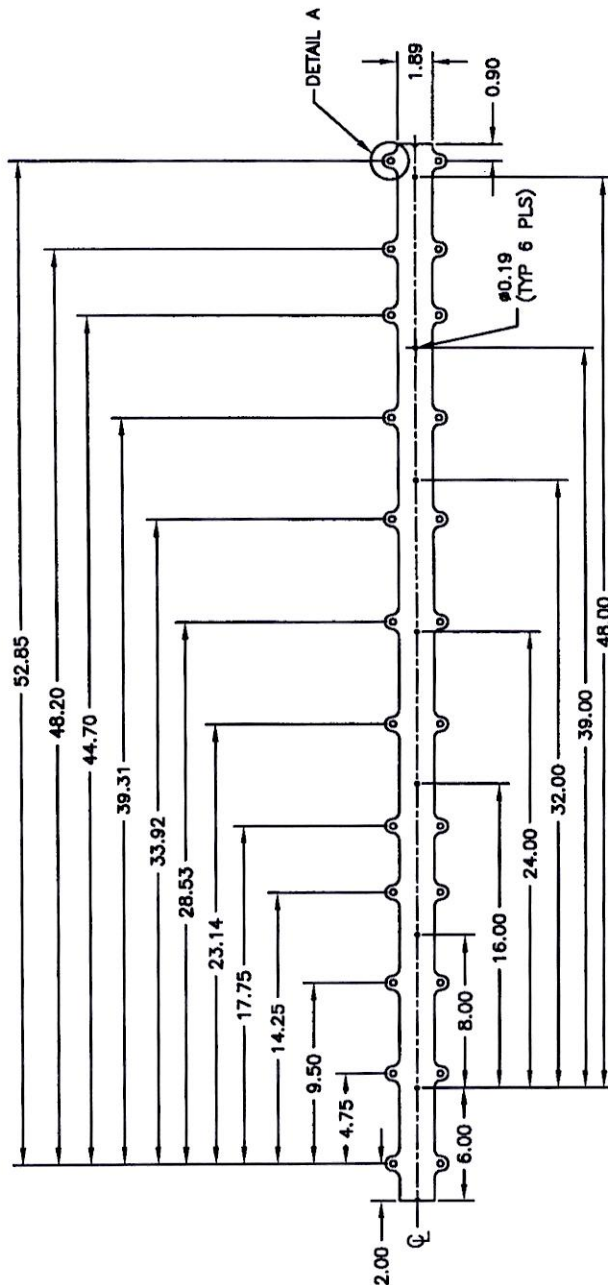
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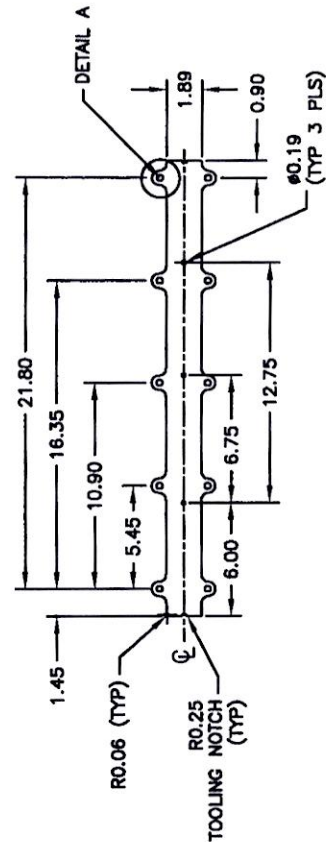


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DATE 06.10.25	TITLE GASKET		SCALE 1:10

RELEASED
07-02-12



D3536-23 GASKET



D3536-25 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
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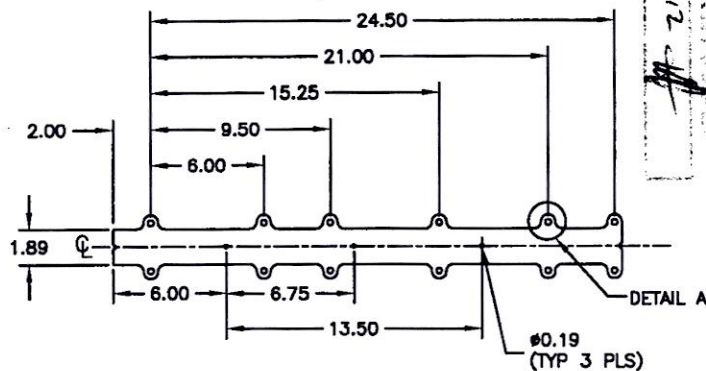
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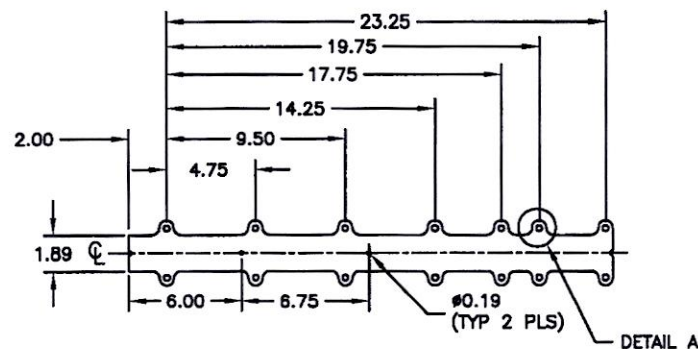
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 4 OF 6
DATE	06.10.25	TITLE	GASKET	SCALE	1:10

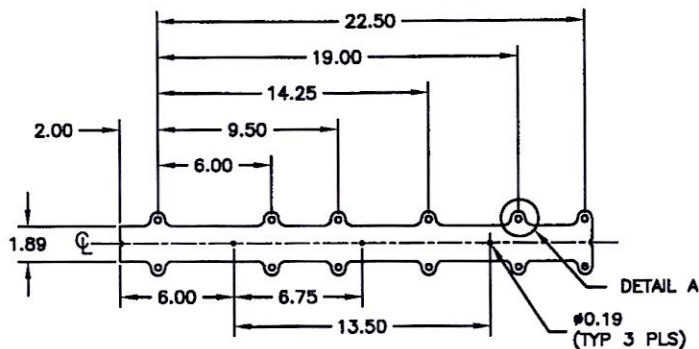
07.02.12



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

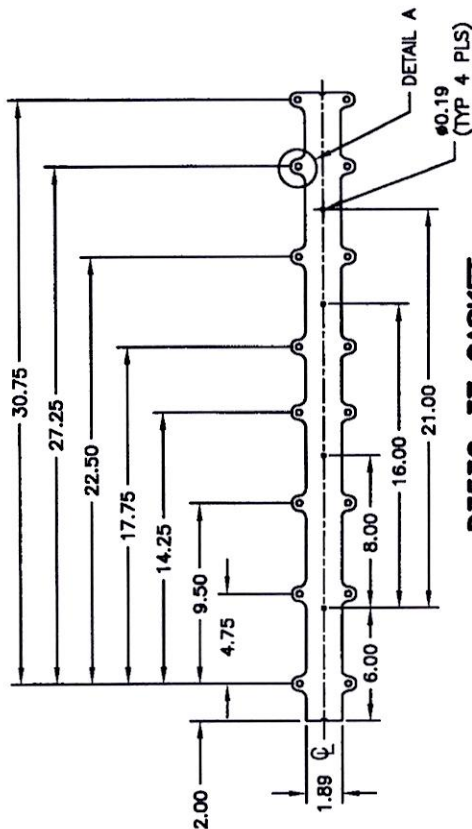
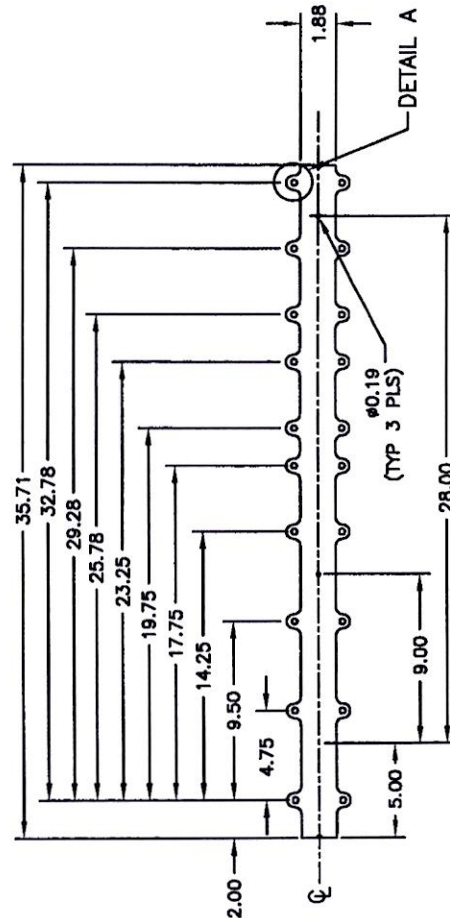
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 5 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

07.02.12 

**D3536-37 GASKET****D3536-39 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\bar{C}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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